



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4956-11
Job Sheet 199513



DAS
21
9-89

Part No: D4956-11

Job Qty: 16 pcs

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/13/19

Description:

Type: SOLD

Note: DWG REV A SHEETS 1,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs	9/13/19	9/13/19	0.17	2.79	Waterjet - Flow	09/11/19	JRB
120	QC 8	16 pcs	9/13/19	9/13/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	16 pcs	9/13/19	9/13/19	0.25	0.78	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		

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				B4B	
140 QC 5	16 pcs	9/13/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 4-1-Assembly-B4B	16 pcs	9/13/19	0.00 0.45	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 3	16 pcs	9/13/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	16	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	

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RD 19-9-5

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pcs

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

180 QC 21 - SA

16

9/13/19

0.00 0.00

pcs

QC 21 - SA - 21

DMS

21

QC 21 - SA - 70

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QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg) FORM JOGGLE AS DWG

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Assemble as per dwg) 1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED

COATING B#: 5203066

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	10.6400 sf (.665 ea)	100-Waterjet - Flow - 1	5175151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	11	235	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	2.193	Diameter
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290	0.307	
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290	0.307	
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875	1.889	
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	5.000Inches ± 0.030	5.030 4.970	4.996	
7	Wearshoe	7.650Inches ± 0.010	7.660 7.640		
8	Wearshoe	11.150Inches ± 0.010	11.160 11.140		
9	Wearshoe	15.400Inches ± 0.010	15.410 15.390		
10	Wearshoe	19.000Inches ± 0.030	19.030 18.970		
11	Wearshoe	19.650Inches ± 0.010	19.660 19.640		
12	Wearshoe	23.150Inches ± 0.010	23.160 23.140		
13	Wearshoe	25.150Inches ± 0.010	25.160 25.140		
14	Wearshoe	28.650Inches ± 0.010	28.660 28.640		
15	Wearshoe	29.030Inches ± 0.030	29.060 29.000		

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____			DISPOSITION						DEPARTMENT / PROCESS											
Part No. _____			Rework ☐ Scrap ☐ Use-as-is ☐						Skid-tube ☐ Machining ☐ Large Fab ☐			Cross tube ☐ Small Fab ☐ Finishing ☐			Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐			Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:		QTY Affected :																	
Description Work Order Deviation			Disposition																	
			Completed By																	
			Lead hand / Supervisor																	
			QC / QA Coordinator																	

Root Cause		FAULT CATEGORY									
☐ Operator	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong							
☐ Manufacturing Process	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance							
☐ Equip/Tooling	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing							
☐ Handling/Preservation	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish							
☐ Material	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing							
☐ Product Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread							
☐ Process Improvement	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up								
☐ Human Factors	Other/Details:										